

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004620**Date Inspected:** 12-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Sun Wei / Sun Bo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Panels**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Bay 3 – New Tower Shop**Visual Testing After Repair**

This QA performed Visual Testing (VT) of completed deck panel repairs. The weld repairs were found visually acceptable per Caltrans Engineer Approved Repair Procedure. The deck panel designation number is as follows: DP088-001, DP303-001, DP493-001, and DP279-001.

Visual Testing Before Repair

This QA Inspector performed an initial visual confirmation of the extent of rejectable indications contained in deck panel designated as DP171-001 and DP198-001. This visual confirmation was performed in conjunction with ABF representative Kevin Chen and ZPMC representative Sun Bo.

Bay 1 – New Tower Shop

This QA Inspector observed ZPMC welding personnel performing Flux Core Arc Welding (FCAW) build up or buttering of longitudinal stiffener plate and skin plate bottom edges on South Shaft / Lift 1 to a thickness of 40mm.

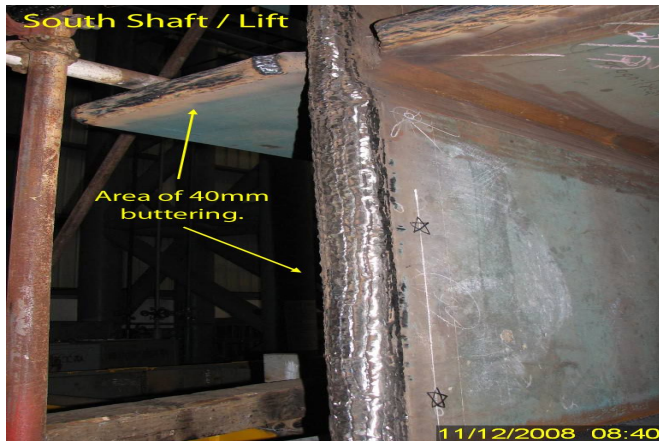
In process FCAW not appear to comply with Caltrans Engineer approved buttering procedure which allows 20mm maximum build up.

Tracking and Log Book

WELDING INSPECTION REPORT

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This QA Inspector reviewed the contract files and tracking logs for the Magnetic Particle Testing (MT), Ultrasonic Testing (UT), Welding Procedure Specifications (WPS), Procedure Qualification Records (PQR), and QC Inspector records for the deck panel repairs to date.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, (858) 232-6799, who represents the Office of Structural Materials for your project.

Inspected By:	Clifford, William	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
